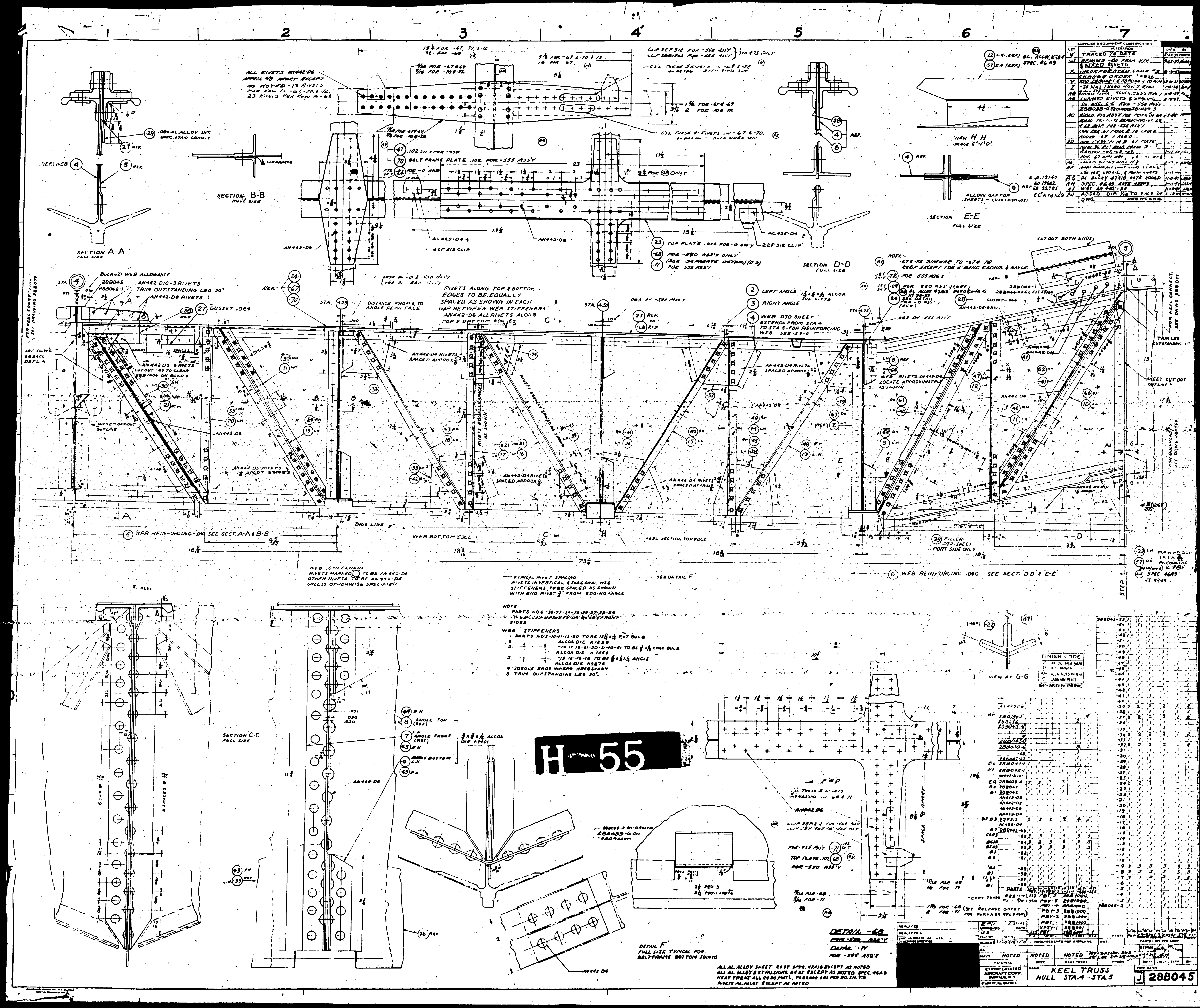
SECTION A-A
FULL SIZE
SECTION B-B
FULL SIZE
SECTION D-D
FULL SIZE
SECTION E-E
FULL SIZE
VIEW H-H
SECTION C-C
FULL SIZE
VIEW AT G-G
ALL RIVETS AN442-D6
RIVETS ALONG TOP & BOTTOM EDGES TO BE EQUALLY SPACED AS SHOWN IN EACH GAP BETWEEN WEB STIFFENERS
AN442-D6 ALL RIVETS ALONG TOP & BOTTOM EDGES
GUSSET .064
LEFT ANGLE
RIGHT ANGLE
WEB .030 SHEET
BASE LINE
WEB BOTTOM EDGE
KEEL SECTION TOP EDGE
WEB REINFORCING .040 SEE SECT. A-A & B-B
WEB REINFORCING .040 SEE SECT. D-D & E-E
FILLER .072 SHEET PORT SIDE ONLY
WEB STIFFENERS
RIVETS MARKED TO BE AN442-D6
OTHER RIVETS TO BE AN442-D5
UNLESS OTHERWISE SPECIFIED
TYPICAL RIVET SPACING
RIVETS IN VERTICAL & DIAGONAL WEB STIFFENERS TO BE SPACED AS SHOWN WITH END RIVET 1/8" FROM EDGING ANGLE
SEE DETAIL F
NOTE
PARTS NO'S -31-33-34-35-36-37-38-39
SIDES
WEB STIFFENERS
1 PARTS NO'S -10-11-12-20 TO BE 1 x 11/16 x 1/16 EXT BULB
ALCOA DIE K1298
2 -14-17-19-21-30-31-40-41 TO BE 7/8 x 3/16 x .060 BULB
ALCOA DIE K1559
3 -13-15-16-18 TO BE 5/8 x 1/2 x 1/16 ANGLE
ALCOA DIE K9876
4 JOGGLE ENDS WHERE NECESSARY
5 TRIM OUTSTANDING LEG 30°
H 55
DETAIL F
FULL SIZE - TYPICAL FOR BELTFRAME BOTTOM JOINTS
DETAIL -68
FOR -550 ASS'Y
DETAIL -71
FOR -555 ASS'Y
ALL AL. ALLOY SHEET 24 ST SPEC. 47A10 EXCEPT AS NOTED
ALL AL. ALLOY EXTRUSIONS 24 ST EXCEPT AS NOTED SPEC. 46A9
HEAT TREAT ALL 24 SO MAT'L. TO 62000 LBS PER SQ. IN. T.S.
RIVETS AL. ALLOY EXCEPT AS NOTED
FINISH CODE
(SEE RELEASE SHEET FOR FURTHER RELEASES)
REQUIREMENTS PER AIRPLANE
PARTS LIST PER ASSY.
NAVY NOTED
NOTED
NOTED
MATERIAL
SPEC.
HEAT TREAT
FINISH
CONSOLIDATED AIRCRAFT CORP. BUFFALO, N.Y.
KEEL TRUSS
HULL STA.4 - STA.5
J 288045